Date:

Wednesday, 27/08/2008 11:34:39 AM

#User:

Julie Lecoca

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 41633 **Estimate Number**

: 12734

P.O. Number

This Issue

: NC

First Issue : //

: 39716

: 27/08/2008

: SMALL /MED FAB Type

Part Number

Drawing Name

: D353525

: WEARSHOE

Drawing Number

: D3535 REV B : N/A

: B

Project Number

Drawing Revision

Material **Due Date**

: 05/09/2008

Qty:

20 Um: Each

Written By

Comment

Previous Run

Prsht Rev.

Checked & Approved By

: Est Rev:A New Issue 07-02-15 JLM

Est Rev:B As per Rev B 07-08-31 JLM

S.O. No. :

Verified By:EC

Additional Product

Job Number:



Sea. #:

Machine Or Operation:

Description:

1.0

M304S20GA

304/316 .040 Sheet



Comment: Qty.:

0.5355 sf(s)/Unit

Total: 10.7100 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch:

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: Prog Rev:



2-Deburr if necessary

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

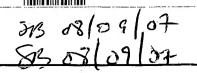
BRAKE NO

NC BRAKE



Comment: NC BRAKE 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326

2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25



Dart Aerospace L	_ta	
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W/O:	*:		WORK	CORDER C	HANGES	i				
DATE	STEP	121	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: _	· 	PAR #:	Fault Category:		NCR: Yes No	DQA:	Date:	
	Resolution:		Disposition:	247	QA: N/C Closed	•	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B	Verification	Annroyal	Approval	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 11:34:39 AM User: Julie Lecoca **Process Sheet** Drawing Name: WEARSHOE Customer: CU-DAR001 Dart Helicopters Services Part Number: D353525 Job Number: 41633 Job Number: Seq. #: Machine Or Operation: Description: QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 10:25 START TIME: **OVEN TEMPERATURE:** FINISH TIME: 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING RESOURCE Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPEC Job Completion

Dart Ae	rospace Li	td •						
W/O:			WORK ORDER (CHANGES				
DATE	STEP	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
	Resc	olution:	Disposition:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDER NON-CON	IFORMANCE (NO	CR)		***************************************	
DATE	CTED	Description of NC	Corrective Actio	n Section B	Verifi	cation	Approval	Approval

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector
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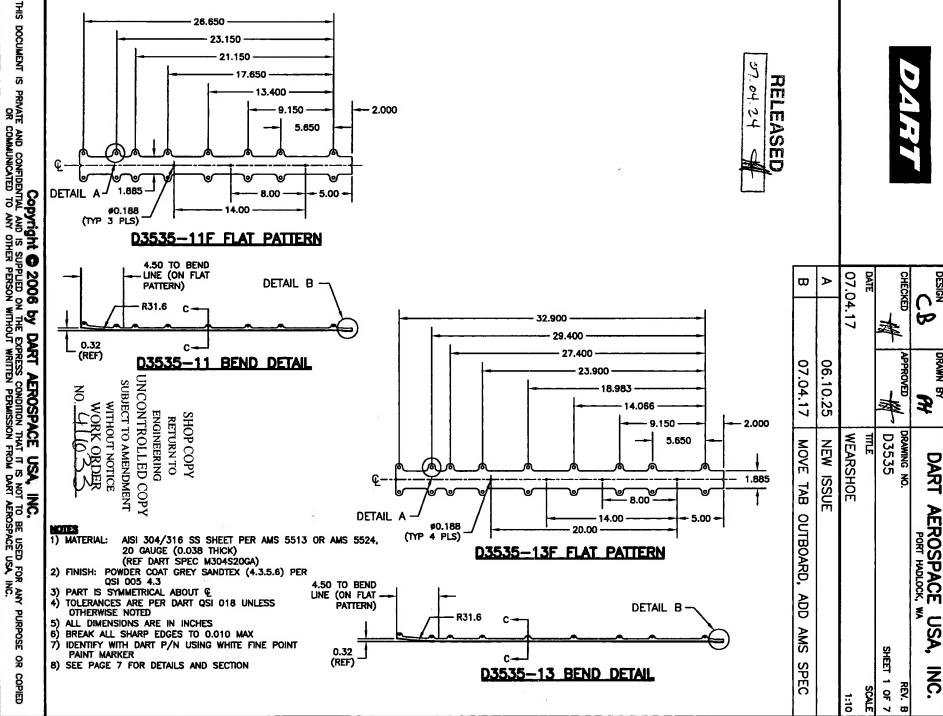
NOTE: Date & initial all entries

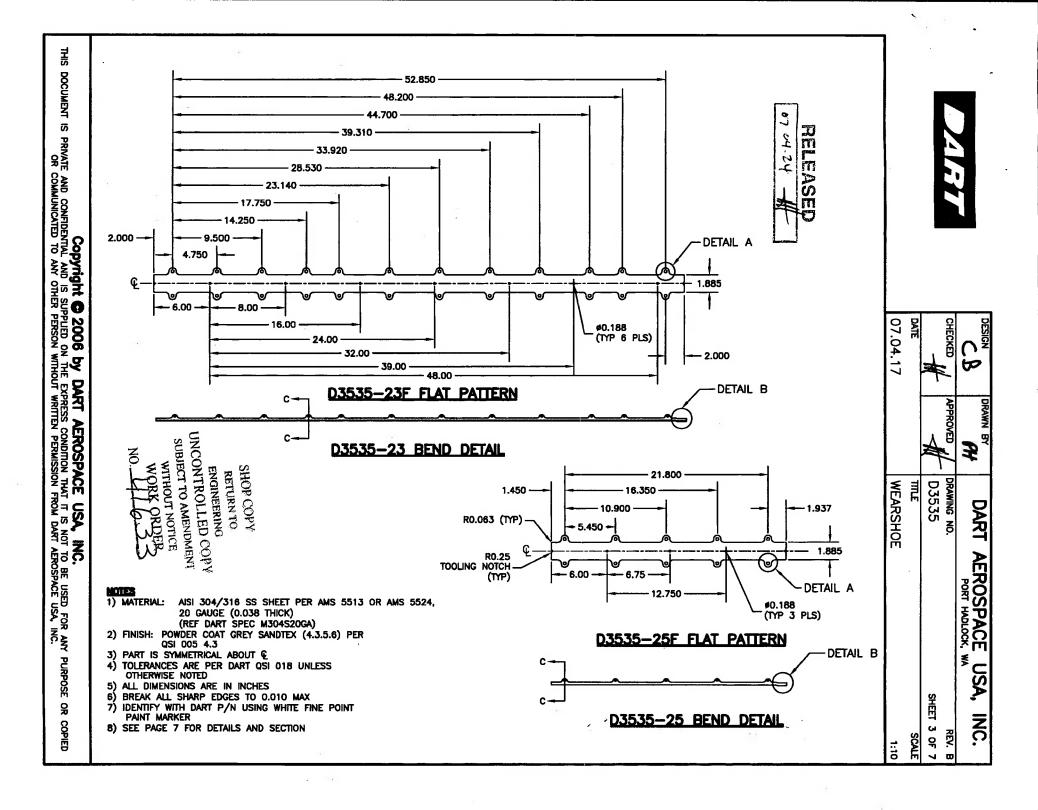
DART AEROSPACE LTD	Work Order:	41653
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

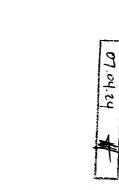
FIRST ARTICLE INSPECTION CHECKLIST **First Article Prototype** Actual **Drawing** Method of Reject **Comments Tolerance** Accept Inspection **Dimension Dimension** 1.885 +/-0.010 888 X 1.937 +/-0.010 Ø 1.450 +/-0.010 16 1.453 5,400 5.450 +/-0.010 ھر 10.900 +/-0.010 (O) POD X 16 ,350 X 16.350 +/-0.010 +/-0.010 21.800 21.800 Ø0.188 +0.005/-0.001 190 12.750 +/-0.010 1215 6.75 +/-0.030 6.75 6.00 +/-0.030 6.00 0.300 +/-0.010 303 0.300 +/-0.010 Ø 303 0.038 +/-0.010 2801 ٠,

Measured by:	Audited by:	Prototype Approval: N/A
Date: 8-9-2	Date: 080907	Date: N/A

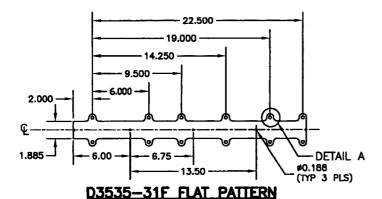
Rev	Date	Change	Revised by	Approved
Α	07.11.23	New Issue	KJ/EC/DD	<i>X</i>
			رم ر- — - الم	







RELEASE



D3535-31 BEND DETAIL

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE ENGINEERING SHOP COPY RETURN TO

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PURPOSE

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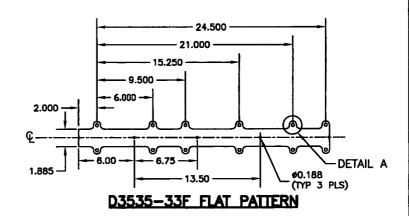
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT Q

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION





80 NOISEIGN	DRAWN BY	DART /	DART AEROSPACE L	W. USA, INC.
CHECKED //	W DEMONED III	DRAWING NO.		REV. B
	4	D3535		SHEET 4 OF 7
DATE		TIME		SCALE
07.04.17		WEARSHOE	•	1:10

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SCALE 1:10

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23.250 19.750 17.750 14.250 9.500 4.750 2.000 #0.188 (TYP 2 PLS) 1.885 -DETAIL A

D3535-35F FLAT PATTERN



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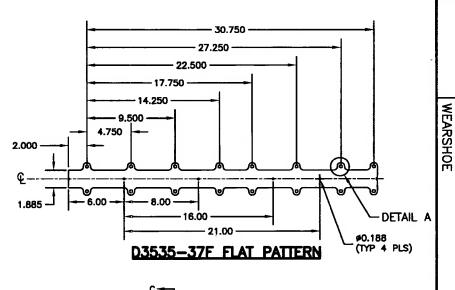
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20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT Q
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



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D3535-37 BEND DETAIL
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36.815 29.275 25.775 23.250 42.40.40 19.750 RELEASE 17.750 Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 14.250 9.500 4.750 1.885 #0.188 (TYP 3 PLS) 2.000 DETAIL A 28.00 D3535-39F FLAT PATTERN R32±2.0--DETAIL B 07.04.17 23.15 ON FLAT PATTERN C-- 5° (REF) 29.079 0.9 25.079 ENGINEERING UNCONTROLLED COPY D3535-39 BEND DETAIL SUBJECT TO AMENDMENT 14.997 WITHOUT NOTICE SHOP COPY RETURN TO 6.932 WEARSHOE 3.432 2.000 1.885 #0.188 (TYP 2 PLS) 4.00 -- 5.00 --DETAIL D3535-41F FLAT PATTERN AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) 1) MATERIAL:

		(REF	DART	SPEC	M304S2	DGA)	
2)	FINISH:	POWDER	COAT	GREY	SANDTEX	(4.3.5.6)	PER
		QSI 005	4.3				
3)	PART IS	SYMMETI	RICAL	ABOUT	€.		
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5) ALL DIMENSIONS ARE IN INCHES

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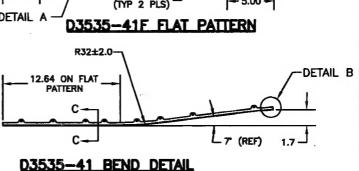
PURPOSE OR

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BREAK ALL SHARP EDGES TO 0.010 MAX IDENTIFY WITH DART P/N USING WHITE FINE POINT

PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION





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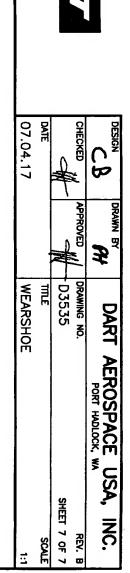
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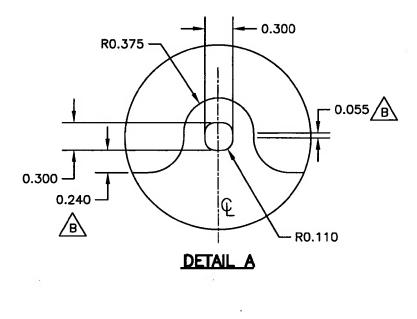
DETAIL B

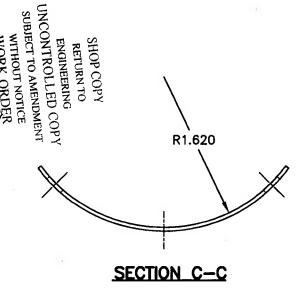
1.000 LONG JOGGLE

0.040 JOGGLE

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